

Work Order ID 67286

Tuesday, March 15, 2011 8:12:33 AM



Page 1

Item ID: D3167-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 3/15/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 3/21/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

*H*Date: *11-03-15* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3167	Rev A1								
120		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut Blank as per File D3167-1_BLANK								
130		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Note: (2) Bearpaw for (1) Kit 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA285 and Dwg D3167 3-Deburr								
140		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

*B11-3-23**(2)**OK 11/04/26**2**OK 11/04/26**2*

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Page 2

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Stop



Item Name: Bearpaw

Start Date: 3/15/2011 Start Qty: 2.00



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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

QC8- Inspect parts - second check

0.00

SL 11/04/26



QC

Memo

0.00

Quality Control

(2)

151

Identify as per dwg & Stock Location: PPD 0.00

Packaging

Memo

67287 0.00

Packaging

11/4/27 (2)

190

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

11/4/27

MF

11-04-27

Picklist Print

Tuesday, March 15, 2011 8:12:39 AM

Page 1

Work Order ID: 67286

Parent Item: D3167-1

Parent Item Name: Bearpaw





Start Date: 3/15/2011

Required Date: 3/21/2011

Start Qty: 2.00

Required Qty: 2.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10 		Purchased	No			120	sf	257.1000	3.6	7.2			
UHMW 1" Black													

B11-3-23

2

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	257.1	
115955	38.8	
116554	108.3	
116796	12	
116797	98	

116797

DART AEROSPACE LTD		Work Order:	47286
Description: Bearpaw		Part Number:	D3167-1
Inspection Dwg: D3167 Rev: A1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.06 x 45°	+0.030/-0.010	0.050 x 45°	—		Vern HL-7	
B	5.80	+/-0.030	5.800	—		"	
C	0.25 x 45°	+/-0.030	0.250 x 45°	—		"	
D	R0.25	+/-0.030	R.250	—		Rad gage	
E	0.200	+/-0.030	.195	—		Vern HL-7	
F	0.250	+/-0.010	.253	—		"	
G	0.625	+/-0.030	.635	—		"	
H	0.375	+/-0.010	.380	—		"	
I	0.950	+0.030/-0.010	.953	—		"	
J	3.21	+/-0.030	3.210	—		"	
K	19.00	+/-0.030	19.000	—		M-type HL-2	
L	Ø0.260	+0.005/-0.000	Ø.261	—		Vern HL-7	
M	Ø0.93	+/-0.030	Ø.932	—		"	
N	0.30	+0.030/-0.000	.308	—		"	
O	0.375	+/-0.030	.386	—		"	
P	7.23	+/-0.030	7.230	—		M-type HL-2	
Q	4.54	+/-0.010	4.540	—		Vern HL-7	
R	2.00	+/-0.030	2.000	—		M-type HL-2	
S	12.000	+/-0.010	12.000	—		"	
T	6.000	+/-0.010	6.000	—		"	
U	23.75	+/-0.030	23.750	—		M-type HL-2	

Measured by:	<i>[Signature]</i>
Date:	11/04/26

Audited by:	<i>[Signature]</i>
Date:	11/04/26

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D130-700-011	KJ/RF <i>[Signature]</i>	<i>[Signature]</i>



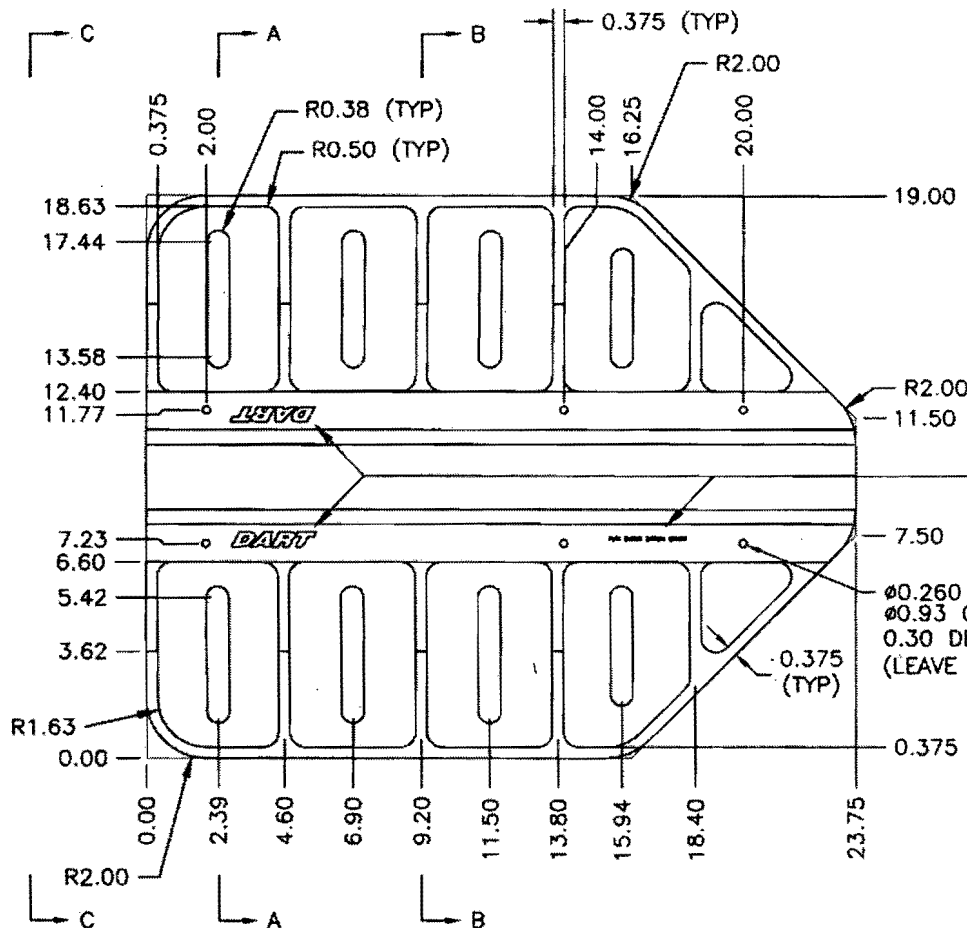
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<i>[Signature]</i>	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D3167
DATE	TITLE	SHEET 1 OF 2
02.10.08	BEARPAW	SCALE
		1:6

A	02.10.08	NEW ISSUE
A1	02.12.17	5.80 WAS 5.50

RELEASED
02.10.25

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67284
PL11-03-15



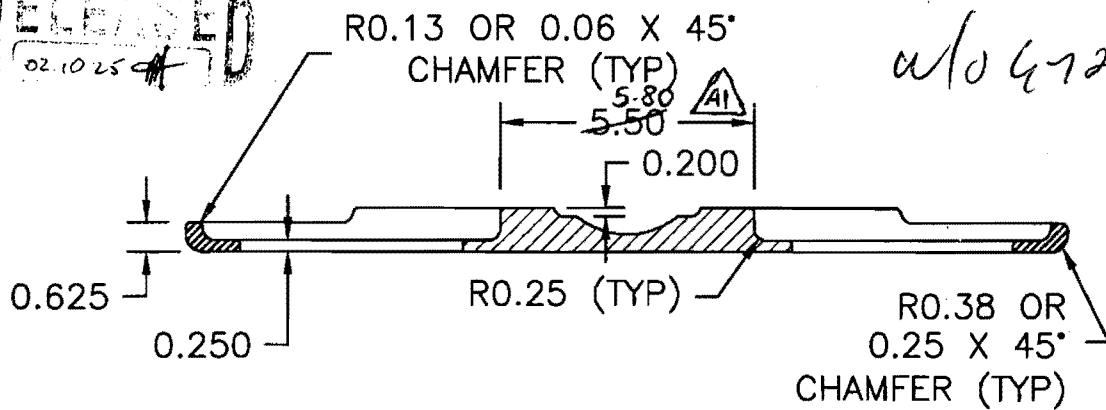
D3167-1

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

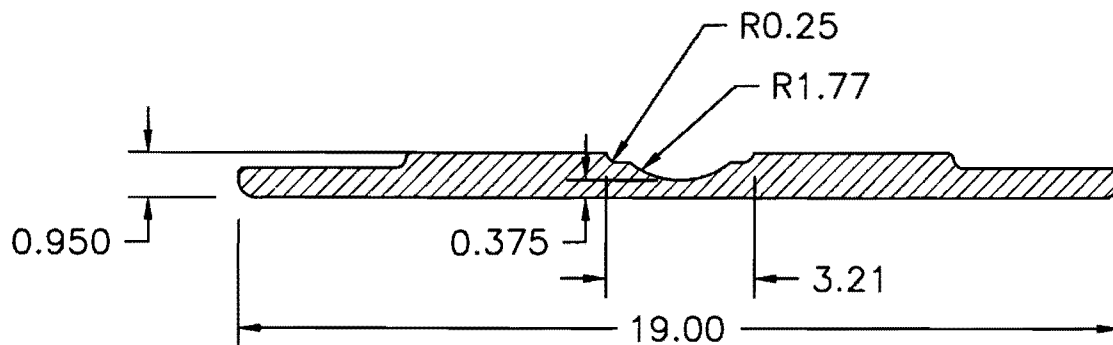


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CHECKED 	APPROVED 	DRAWING NO. D3167	REV. A SHEET 2 OF 2
DATE 02.10.08		TITLE BEARPAW	SCALE 1:4

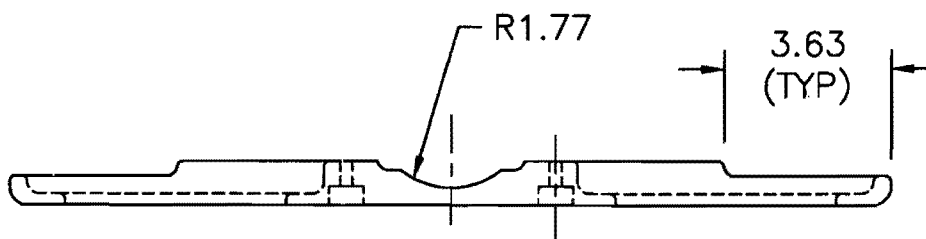
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02.10.25



SECTION A-A



SECTION B-B



SECTION C-C

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